

Work Order ID 66022

Tuesday, February 01, 2011 3:30:32 PM

PRELIMINARY ISSUE

Page 1

Item ID: D4093-1

Accept

Revision ID:

Item Name: Bracket

Start Date: 2/1/2011 Start Qty: 2.00

Required Date: 2/7/2011 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:



Approvals:

Process Plan:

Date: 11-02-1

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4093

PBI 11-02-02

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

CUT AS DWG

DWG REV: PBI

PROG REV: PBI

DEBURR

1B11-2-3

2

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

1B11-2-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66022



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Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 2/1/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00 inspect to PBI Day only



QC

Memo

0.00

Quality Control

132

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

DRILL AS PER DWG

135

QC5- Inspect part completeness to step on W/O

0.00 - inspect to PBI



QC

Memo

0.00

Quality Control

Day only
2/1/2011

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Start Date: 2/1/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

11-02-11

11/02/10

X2

11-02-11



HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

N/A
11-02-03
This Batch only

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 BR 11-02-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 2/1/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

4/3/4

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF
11-08-04

201340

101340

POSITIVE RECALL

POSITIVE

11/02/02

AUTH

EB

DATE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Tuesday, February 01, 2011 3:30:43 PM

Work Order ID: 66022

Parent Item: D4093-1

Parent Item Name: Bracket



Start Date: 2/1/2011

Required Date: 2/7/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: Ipp Rev:A New Issue 10-05-31 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X06.00 0		Purchased	No				f	28.5800		2			



6061T6 BAR .750 X 6.00



IB 11-2-3

Location

Loc Qty

Loc Code

MAT03

28.58

112567

28.58

112567

2

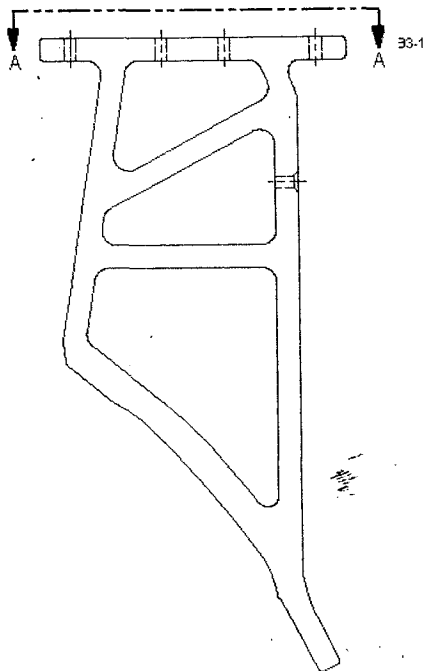
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

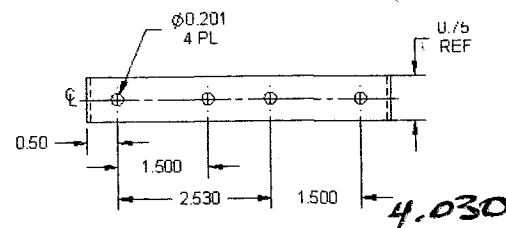
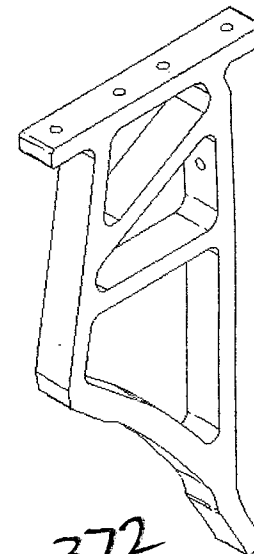
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



w/066022



SECTION VIEW A-A D6-1

372
745

PRELIMINARY ISSUE

11.01.31

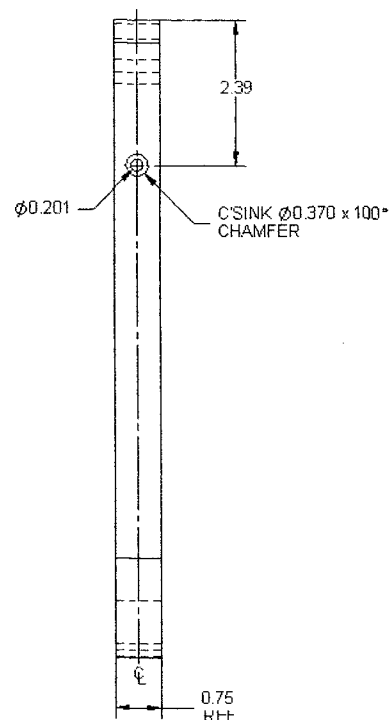
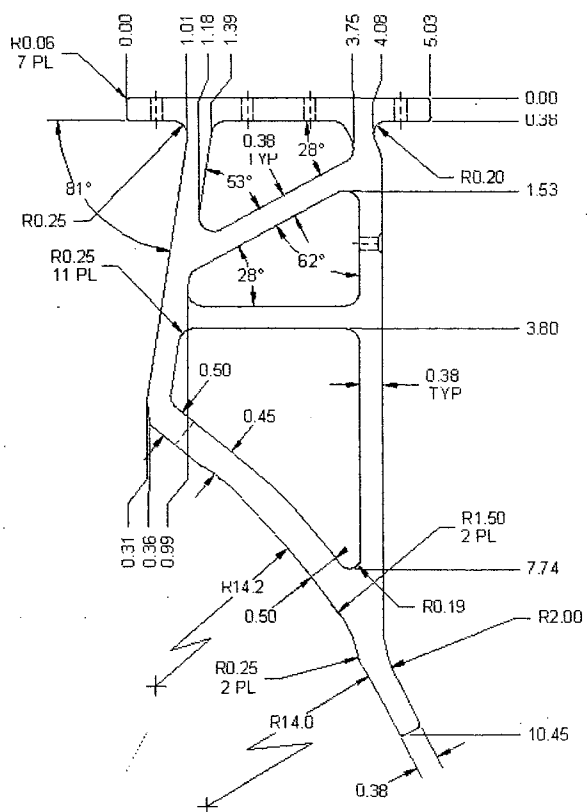
D4093-1 BRACKET



NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/6 OR AMS-QQ-A-225/6 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/6 OR AMS-QQ-A-200/6 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.91 lbs

PB1	REDRAWN D4093-1/3	RF	11.01.31
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED			
MFG. APPR.			
DE APPR.			
DATE	11.01.31	DRAWING NO. D4093 REV. PB1 TITLE BRACKET SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS LOANED TO YOU BY DART AEROSPACE USA, INC. IT IS NOT TO BE REPRODUCED OR COPIED OR COMBINED WITH ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



D4093-1 BRACKET



PRELIMINARY ISSUE

11.01.31

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		D4093	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.01.31	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS AVAILABLE ON THE OPEN SOURCE CONDITION THAT IT IS NOT USED FOR THE PURPOSE OF COPIES OR CHANGES TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

DART AEROSPACE LTD		Work Order: 66072
Description: BRACKET		Part Number: D4093-1
Inspection Dwg: D4093-1, Rev: PB1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.01	±.030	1.011	✓		✓ IR 02	
1.18	±.030	1.182	✓		✓	
1.39	±.030	1.392	✓		✓	
3.75	±.030	3.755	✓		✓	
4.08	±.030	4.071	✓		✓	
5.03	±.030	5.019	✓		✓	
.38	±.030	.385	✓		✓	
1.53	±.030	1.516	✓		✓	
3.80	±.030	3.810	✓		✓	
7.74	±.030	7.739	✓		✓	
10.45	±.030	10.439	✓		PROW 3-02	
.50	±.030	.504	✓		✓	
.38	±.030	.387	✓		✓	
.45	±.030				✓	
.38	±.030	.366	✓		✓	
.45	±.030	.454	✓		✓	

Measured by: IB	Audited by: S	Prototype Approval:
Date: 11-2-3	Date: 11/02/03 inspected to PB1	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

